



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-011
Job Sheet 178456



Part No: D3391-011

Job Qty: 1 ea

Part Name: Fwd Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/29/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV J SHEETS 3,5 IPP A 05.09.13 New issue KJ/JLM IPP B IPP C 07.03.13 revF dwg ec IPP D 07.11.01 ecn1053P EC IPP Rev:E ECN 1056 07-11-12 DD verified by:EC IPP Rev:F 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H 10.04.07 add part in bom DD verified by:JLM IPP Rev:I 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S076960



Part: D3391-011

Job No: 178456

Serial No/Batch: S076960

Revision:

Inspector:

Exp Date: 05/31/2018

Instructions:

Date: 05/31/18

Job Routing

005637

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Skid tubes-1		MGB
100	Skid tubes	1 pcs	6/29/18	6/29/18	0.00	0.91	Skid tubes-3		MGB
110	CNC Bend Skid tubes	1 pcs	6/29/18	6/29/18	0.00	1.05	CNC Bend Skid tube		
120	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		BE
130	CNC Vertical Machining	1 pcs	6/29/18	6/29/18	2.76	1.05	HAAS1-3		Kt 2018-06-12
140	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC2 Machining-2		Kt 2018-06-12
150	Mill Conv	1 pcs	6/29/18	6/29/18	0.00	0.26	Mill Conv 1		
160	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC2 Machining-2		MGB
170	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-2		MGB
180	Skid tubes	1 pcs	6/29/18	6/29/18	0.00	0.91	Skid tubes-3		MGB
190	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		38
200	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.38	HandFinish1		SA 18-07-10
210	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC7-2		BE
220	Skid tubes	1 pcs	6/29/18	6/29/18	0.00	0.91	Skid tubes-3		MGB
230	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		38
235	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.38	HandFinish2		SA 18-07-20
240	SprayPaint	1 pcs	6/29/18	6/29/18	0.00	0.64	Spray Paint		JUL 24 2018
250	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC14		18-9-25
255	Skid tubes	1 pcs	6/29/18	6/29/18	0.00	0.91	Skid tubes-3		18-9-25
257	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		21
260	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1		SEP 25 2018
280	QC21-SA	1 Ea	6/29/18	6/29/18	0.00	0.00	QC21		SEP 25 2018

Part Op 100 - Cut as per dwg.

Descriptions: 110 - Bend as per Dwg D3391

130 - 1-Machine as per Folio FA590 Rev. ____ & Dwg D3391 Rev. ____ Identify as D3391-1

150 - 1-Drill .1875" at end of tube as per Dwg D3391

180 - 1- Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step (Do not open tow cap holes to finish size) 2- Drill and float bag holes as per Dwg D3391 using DT8798 (DRILL ALL HOLES) 3- Open tow cap holes to .208" as per Dwg D3391 4-Open Tow Ring hole to .640" as per Dwg D3391 5- open float bag holes 0.328" and counter sink as per dwg D3391 6-Deburr and scribe batch # inside aft end 7- transfer drill D3391-011 with D3391-013 ***NO WEARPLATE HOLES ARE TRANSFER DRILLED*** MID TUBE BATCH

5078351

200 - REALODINE AS PER PAR09-043

220 - 1-Install crossbolt spacers per dwg D3391 A/R Magnabond 6398 batch: 5090785 2- Grind flush 3- back drill crossbolt if necessary

235 - AND REALODINE AS PER PAR09-043

240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5084461 PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: 138886

255 - **** install D3591-1 spacer as per DSI9364 and wearplate as per DWG ****

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6013-047	Skid tube Material	1 Ea (1 ea)	90-Start up Operation	B 800064
D3670-4-200	Bushing	9 Ea (9 ea)	220-Skid tubes	5077425
AFS 1032-225	Insert	10 Ea (10 ea)	255-Skid tubes	5058139
AN3C4A	Bolt	10 Ea (10 ea)	255-Skid tubes	5095223
D3401-041	Tow Cap Assembly	1 Ea (1 ea)	255-Skid tubes	5071282
D3672-1	Washer, Phenolic	4 Ea (4 ea)	255-Skid tubes	5163255-1
D4095-051	Wearpad Fwd	1 Ea (1 ea)	255-Skid tubes	M 159902-127
NAS1149C0332R	Washer	10 Ea (10 ea)	255-Skid tubes	5071663

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6013-047	1	44	0
220-Skidtubes	D3670-4-200	9	32	0
255-Skidtubes	AELS-1032-225	10	0	0
	AN3C4A	10	1,908	0
	D3401-041	1	7	0
	D3672-1	4	1,088	0
	D4095-051	1	25	0
	NAS1149C0332R	10	6,681	0
Part Specifications				
Specifications could not be found.				

Plex 5/31/18 2:12 PM dart.white.jesse

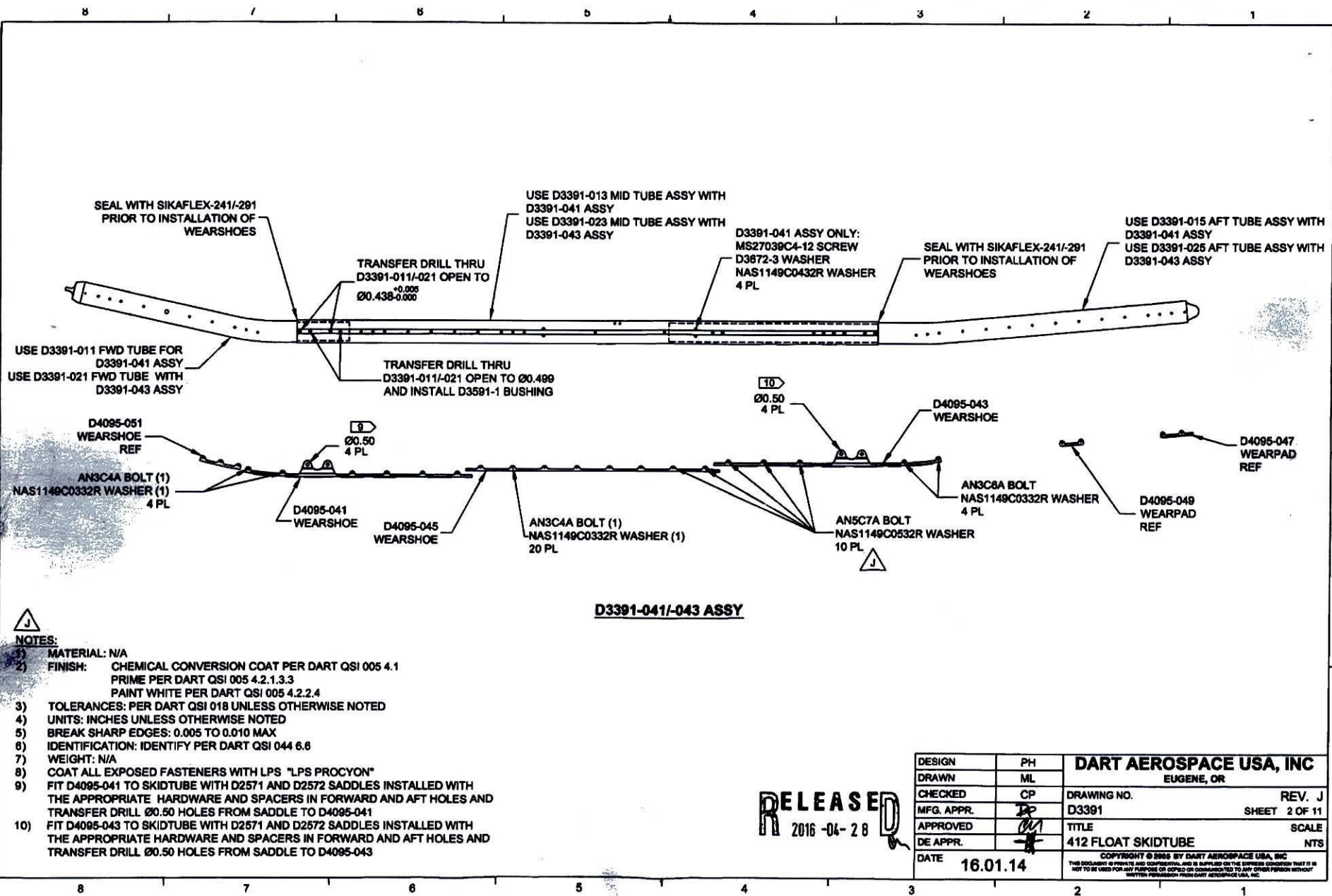
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3CA4	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER

J

J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B8-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B8-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
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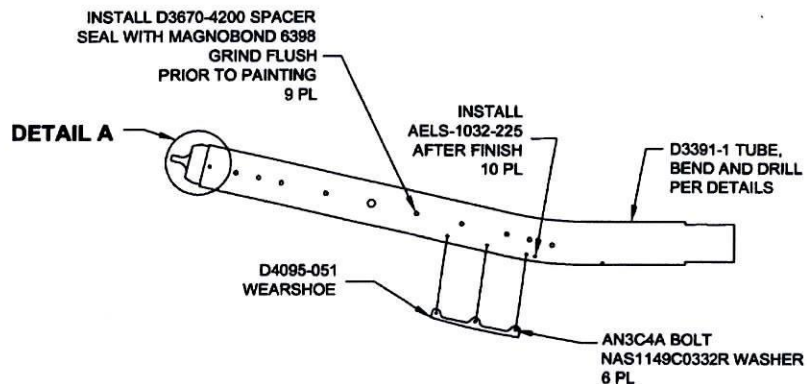
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2016-04-28
ECN 16-516



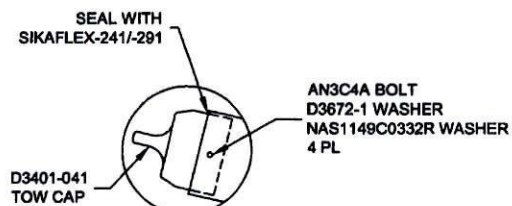
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.8
 - 7) WEIGHT: N/A
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
 - 9) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
 - 10) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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R 2016-04-28

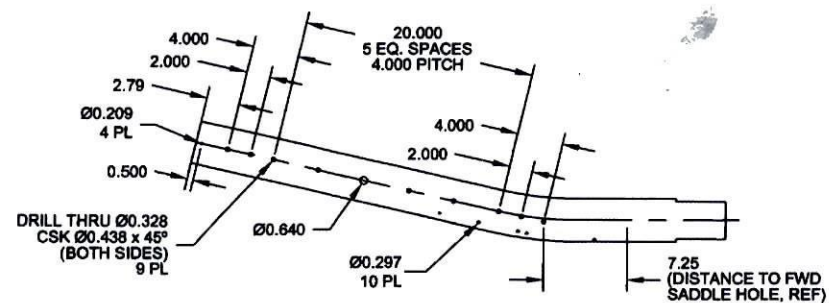
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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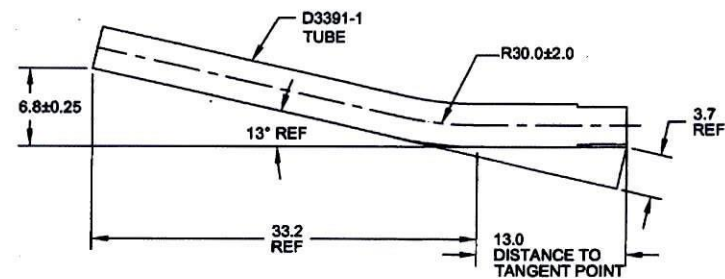
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



DETAIL A
SCALE 2X



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER

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MFG. APPR.		D3391	SHEET 3 OF 11
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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2016-04-28

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



D4095-051
WEARSHOE

INSTALL
AELS-1032-225
AFTER FINISH
10 PL

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

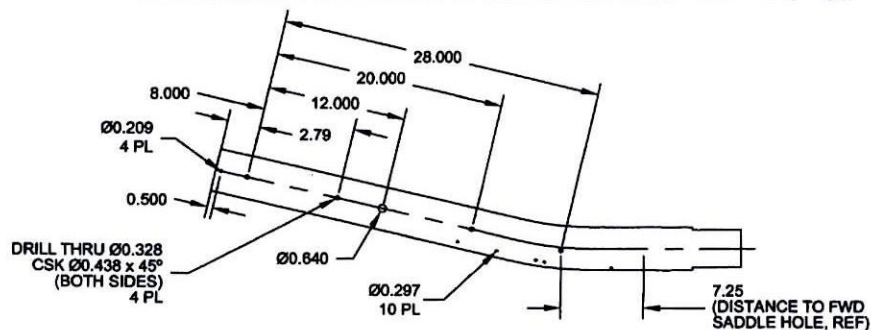
D3401-041
TOW CAP

DETAIL B SCALE 2X

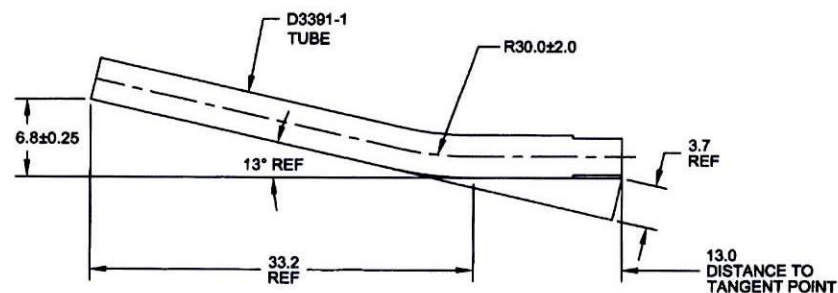
AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



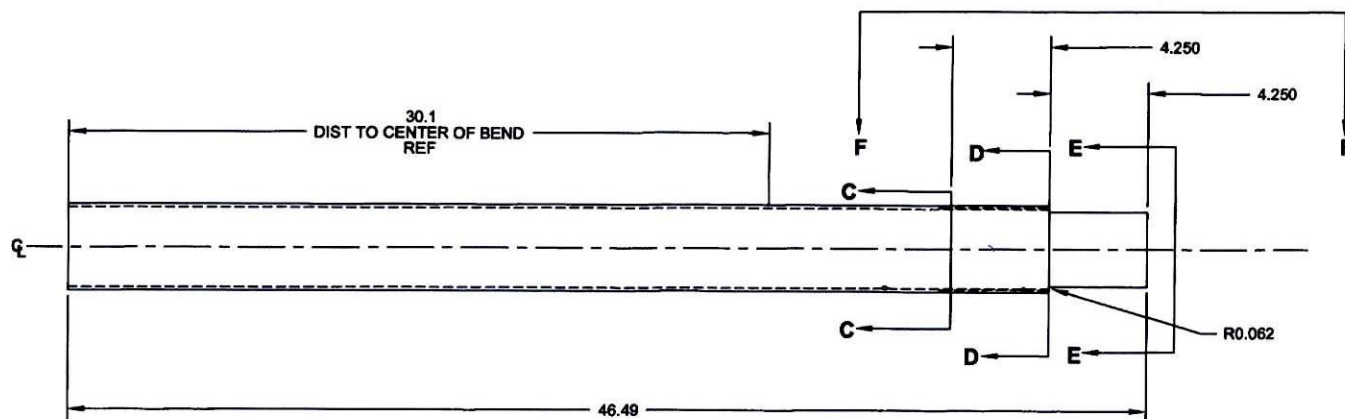
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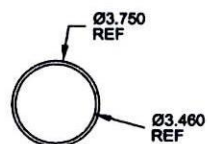
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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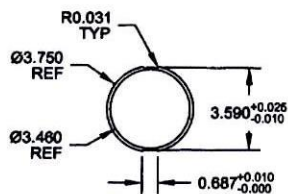
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DRAWN	ML	EUGENE, OR	
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MFG. APPR.	TS	D3391	SHEET 4 OF 11
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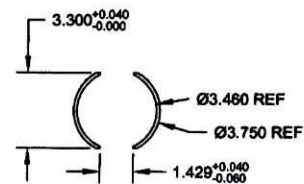
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



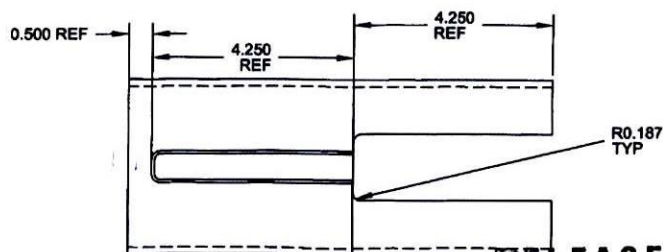
SECTION C-C



SECTION D-D



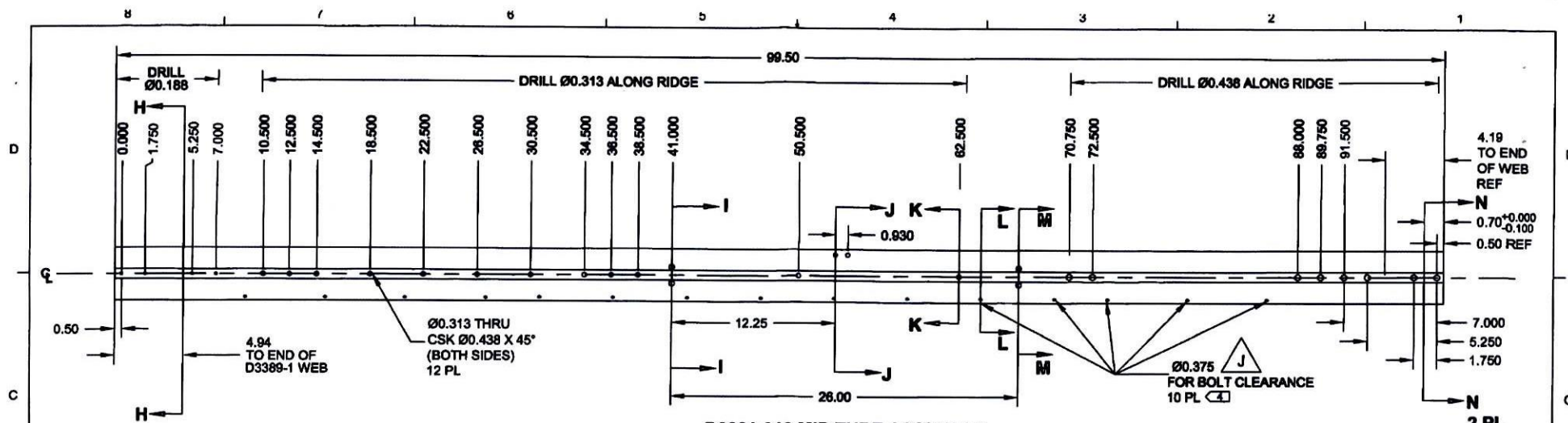
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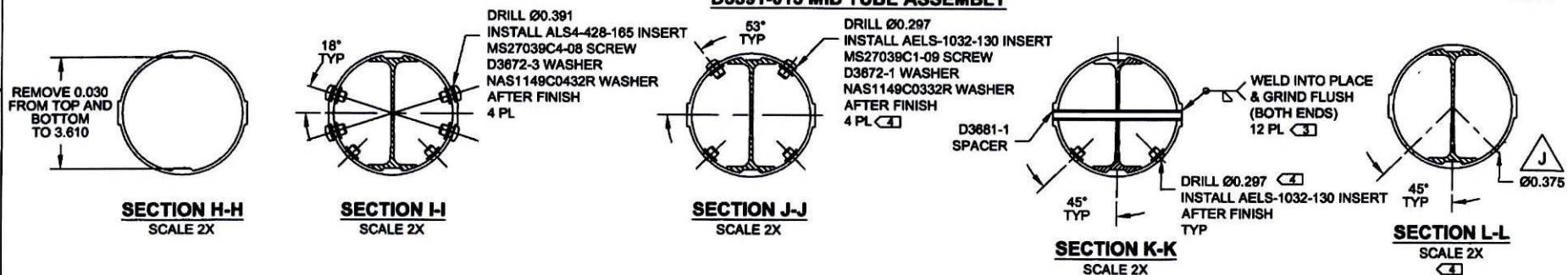
VIEW F-F
SCALE 2X

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D3391-013 MID TUBE ASSEMBLY



D3391-013 MID TUBE ASSEMBLY PARTS LIST

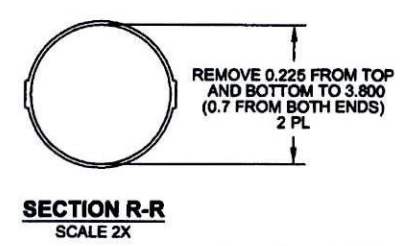
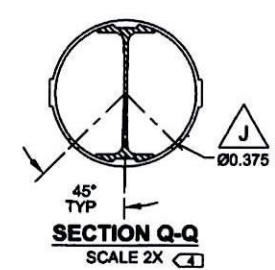
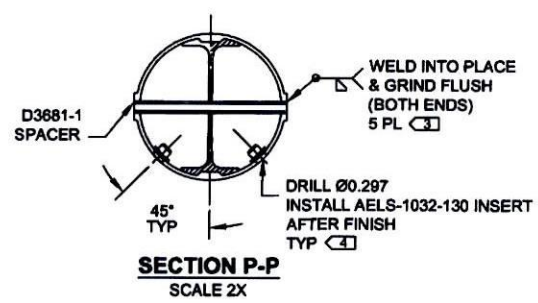
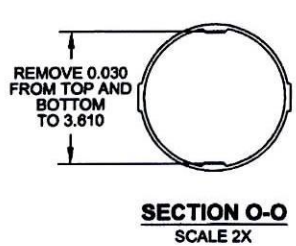
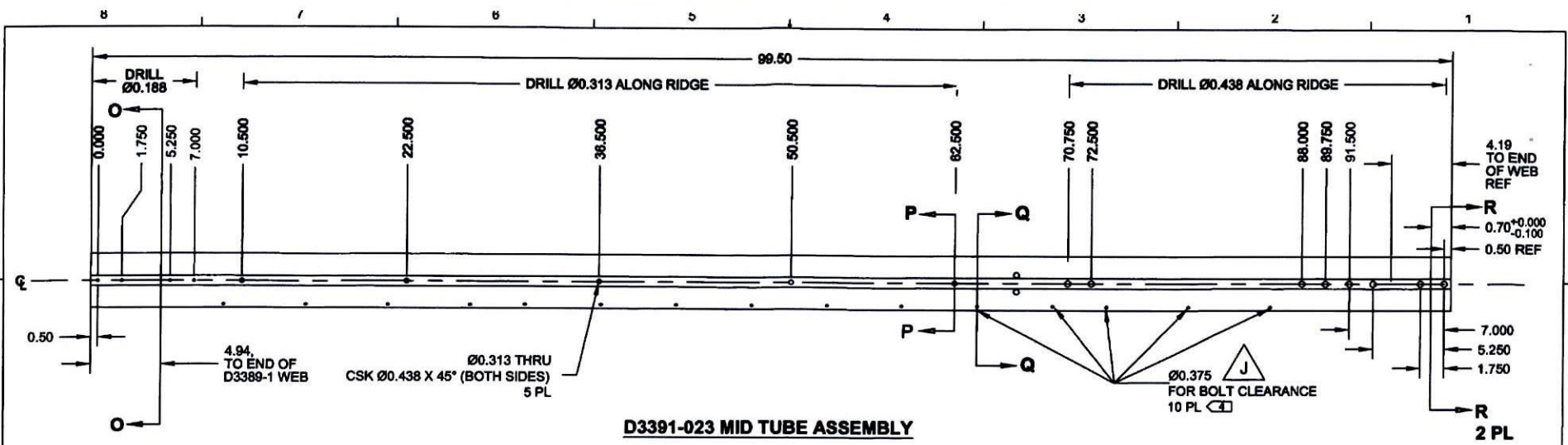
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.		D3391	SHEET 6 OF 11
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2016-04-28



D3391-023 MID TUBE ASSEMBLY PARTS LIST

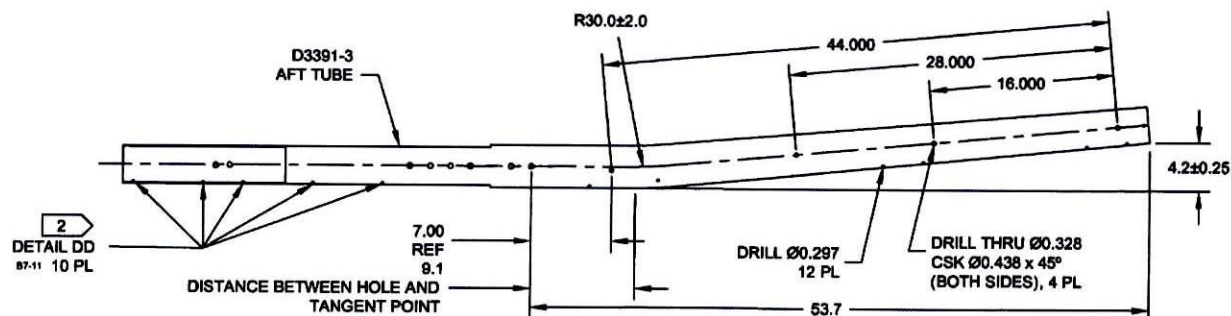
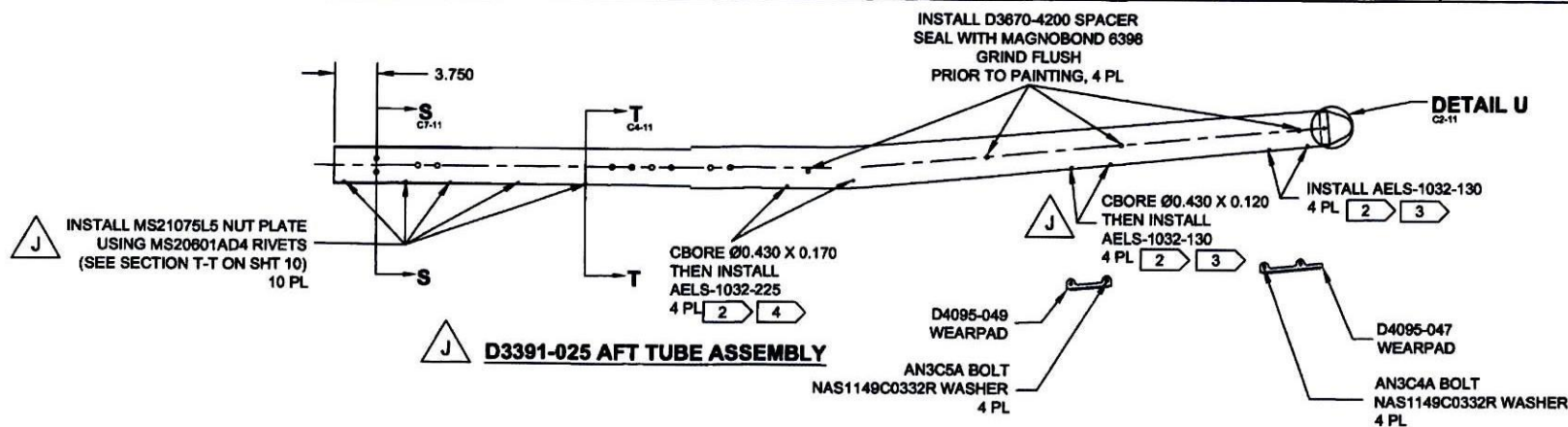
QTY	PART NUMBER	DESCRIPTION
-023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004
 - 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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RELEASED
2016-04-28



D3391-025 AFT TUBE ASSEMBLY PARTS LIST

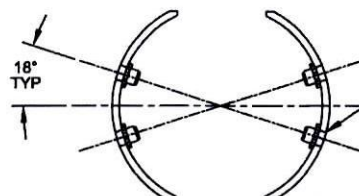
QTY	PART NUMBER	DESCRIPTION
1	D3391-025	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20801AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

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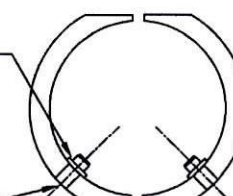
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT TUBE ASSEMBLY	NTS
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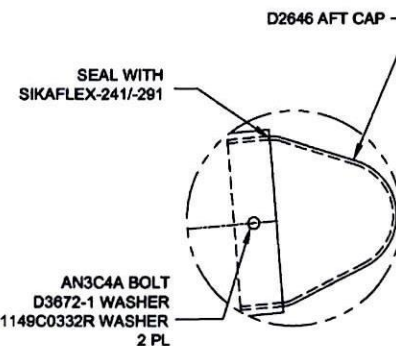
SECTION S-S D6-8.9
SCALE 5X

MS21075L5 NUTPLATE REF
USE DT8217 DRILL TEMPLATE TO LOCATE HOLES AND OPEN TO Ø0.375

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



SECTION T-T D6-8.9
SCALE 5X
5 PL

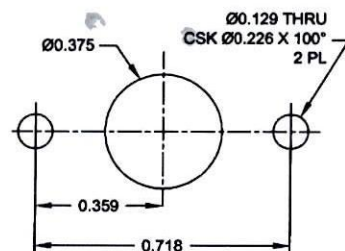


DETAIL U D1-8.9
SCALE 5X

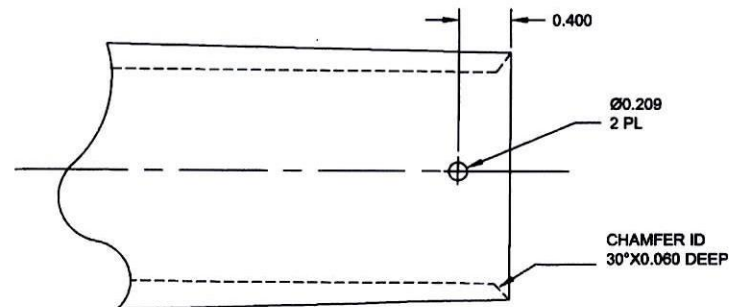
SEAL WITH
SIKAFLEX-241/-291

AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
2 PL

D2646 AFT CAP



DRILLING DETAIL DD D7-8.9
SCALE 10X



DETAIL EE D1-11
SCALE 2X

Ø0.209
2 PL

CHAMFER ID
30°X0.060 DEEP

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NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	Y2	D3391	SHEET 11 OF 11
APPROVED	Y2	TITLE	SCALE
DE APPR.	Y2	AFT TUBE ASSEMBLY	NTS
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